NIMROD AKS

MMA (SMAW)

ALL-POSITIONAL INCONEL™ TYPE MMA ELECTRODE

PRODUCT DESCRIPTION

MMA electrode with a basic flux system on a nearly matching core wire designed to give radiographically sound weld metal.
It is optimised for DC+ welding in all positions including pipework in the ASME 5G/6G positions.
Recovery is about 110% with respect to core wire, 65% with respect to whole electrode.

CLASSIFICATIONS

AWS A5.11M	ENiCrFe-2
ISO 14172	E Ni 6133

ASME IX QUALIFICATION

QW432 F-No 43

WELDING POSITIONS (ISO/ASME)

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Nb	Fe	Mo	Cu	Co *	Ta *
min.	--	1.0	--	--	--	13.0	62	1.5	--	1.0	--	--	--
max.	0.10	3.5	0.75	0.015	0.02	17.0	Bal	3.0	12.0	2.5	0.50	0.12	0.30
Typical	0.05	2.8	0.5	0.01	0.01	16	69	2	8	1.5	0.05	0.05	0.05

* Co and Ta maximums only when specified at time of order.

ALL-WELD MECHANICAL PROPERTIES

As-welded		Min.	Typical
Tensile strength (MPa)		550	700
0.2% proof strength (MPa)		360	420
Elongation (%)	4d	30	42
	5d	27	39
Reduction of area (%)		--	50
Impact ISO-V(J)	-196°C	--	110
Hardness (HV)		--	200/215

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	60	70	100
max. A	80	110	155

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	NIMAKS-25	240	720	4.2	12.6
	3.2	300	NIMAKS-32	150	450	4.2	12.6
	4.0	350	NIMAKS-40	93	279	4.8	14.4

Redrying : 200 – 250°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total.

FUME DATA (WT % TYPICAL)

Fe	Mn	Ni	Cr	Mo	Cu	F	OES (mg/m3)
2	13	10	5	0.2	0.1	15	1